

boring operations are to be performed in two directions, a jig on the lines indicated in Fig. 7 is designed. This jig may be mounted on a special revolving table permitting the work and the jig to be turned and indexed so as to save resetting and readjusting the work and jig when once placed in position on the machine.

The foregoing outline of boring jigs illustrates only the fundamental principles involved, it being considered more important to state the fundamental principles in this connection than to describe complicated designs of tools in which the application of such principles may be more or less obscure or hidden.

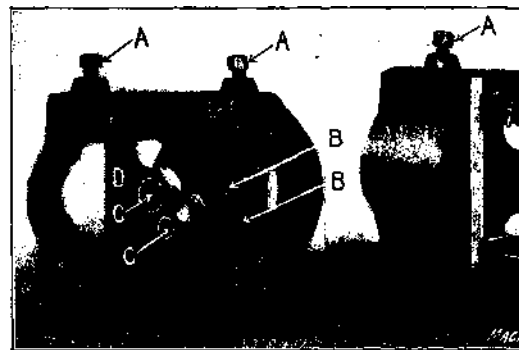


Fig. 8. Example of Small Boring Jig, with Removable Leaf for Holding Guide Bushings

Boring Jig Designs. — In Fig. 8 are shown two views of a small jig supported directly on the work to be bored. This jig is used for boring out a cross-slide carriage, and is located on the work by the dovetail slide and held in place by the two set-screws *A*. The two bushings *B* are driven into the solid part of the jig and the two corresponding bushings *C* are placed in the loose leaf *D*

which is removed when the jig is placed in position on, or removed from, the work. The two set-screws *A* do not bear directly on the side of the carriage, but are provided with brass or steel shoes. The leaf *D* cannot be attached permanently to the jig and simply swung out of the way when the jig is located on the work, because it could not be swung in place after the jig is applied on account of the small clearance